



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4038-4

Job Sheet 187144



Part No: D4038-4

Job Qty: 2 ea

Part Name: Angle, Aft, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4038 REV.F SHEET 6 lpp Rev:A New Issue 09-12-15 JLM Verified By:EC IPP REV:B 18.02.08 AS
PER DWG REV.F DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-2		Marie 17/01/13
100	Bandsaw	2 pcs	12/14/18	12/14/18	0.00	0.14	Bandsaw1		11/01/14
110	CNC Vertical Machining	2 pcs	12/14/18	12/14/18	0.00	2.15	HAAS1-4		Marie 19/01/14
120	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC2 Machining-2		
130	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-2		Marie 19/01/14
140	HandFinish	2 pcs	12/14/18	12/14/18	0.00	0.14	HandFinish1		D.R 19/01/14
150	QC	2 pcs	12/14/18	12/14/18	0.00	0.00	QC3		38
160	Packaging	2 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2	Stones	JAN 15 2019
170	QC21-SA	2 Ea	12/14/18	12/14/18	0.00	0.00	QC21		21 JAN 15 2019

Part Op 100 - Cut Blank 7.625" long

Descriptions: 110 - Mill as per Dwg & Folio FA880 Dwg Rev: F Folio Rev: AA Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6A4.000W.250	6061T6 Angle 4.00 X 4.00 X .250	1.7500 ft (.875 ea)	90-Start up Operation	5068499-3.25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6A4.000W.250	2	20	0



Container No: S144397



Part: D4038-4

Job No: 187144

Serial No/Batch: S144397

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/13/19

ifications

uld not be found.

Plex 11/28/18 9:54 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
FAULT CATEGORY							
		☐ Contamination		☐ Power Loss/Surge		☐ Positioned Wrong	
		☐ Misaligned/off center		☐ Folio/Program		☐ Outside Tolerance	
		☐ BOM/Route		☐ Grain Direction		☐ Drawing	
		☐ Broken/Damage/Defect		☐ Weld		☐ Finish	
		☐ Incomplete/Unclear Instructions		☐ Wrong Stock Pulled		☐ Part Lost/Missing	
		☐ Drill Holes		☐ Out of Sequence		☐ Misread	
☐ Fit/Function		☐ Off-set/Set-up					

DART AEROSPACE LTD		Work Order: 182144
Description: Angle, Aft, RH		Part Number: D4038-4
Inspection Dwg: D4038	Rev: F	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	4.00	/		vern	mark-5
1.250	+/-0.010	1.250	/			
1.25	+/-0.030	1.250	/			
4.00	+/-0.030	4.000	/			
0.250	+/-0.010	.251	/			
R0.25	+/-0.030	.25	/		Rad G	
0.581	+/-0.010	0.571	/		vern	mark-5
0.669	+/-0.010	0.669	/			
2.904	+/-0.010	2.904	/			
0.735	+/-0.010	0.735	/			
0.500	+/-0.010	0.500	/			
2.00	+/-0.030	2.00	/			
0.500	+/-0.010	0.500	/			
Ø0.316	+0.006/-0.001	0.319	/			
Ø0.189	+0.005/-0.001	0.191	/			
R0.13	+/-0.030	0.13	/		Rad G	
0.70	+/-0.030	0.700	/		vern	mark-5
1.000	+/-0.010	1.000	/			
1.500	+/-0.010	1.494	/			
1.00	+/-0.030	1.00	/			
1.19	+/-0.030	1.190	/			
2.125	+/-0.010	2.125	/			
0.589	+/-0.010	0.586	/			
R0.13	+/-0.030	0.130	/		Rad G	
1.270	+/-0.010	1.268	/		vern	mark-5
1.750	+/-0.010	1.750	/			
7.500	+/-0.010	7.498	/			
0.50	+/-0.030	.500	/			

Measured by: mark	Checked by: ant	QC Inspector:
Date: 19/01/13	Date: 19/01/14	Date:

Engineering Approval: (if necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dimensions updated per Dwg Rev D	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	
D	18.08.01	Dwg Rev updated	KJ	